

Date: Tuesday, 11/13/2007 1:24:08 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 35649-1
Estimate Number : 13008
P.O. Number :
This Issue : 11/13/2007 S.O. No. :
Prsht Rev. : NC Part Number : D3245041
First Issue : 11 Drawing Number : D3245 REVB
Previous Run : 34551 Type : SMALL /MED FAB Project Number : N/A
Material : B
Due Date : 11/28/2007 Qty: 6 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-09-11 JLM Verified By:EC
Est Rev:b ECN 1052 07-10-31 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0 D32451 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Panel
Batch: B 35658

SR 08/01/15

3.0 D32455 Angle Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Angle Plate
Batch: B 35047 x 16 B 35067 x 16

AS 02/12/19

4.0 235018C3Y RIGID RECEPTACLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)
RIGID RECEPTACLE
Batch: M 106037

M105729 x 16

M106810 x 32

MF 08-01-15

AS 07/12/19

5.0 MS20427M33 Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)
Rivet
Batch: M 105940 x 96

AS 07/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:24:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35649

Part Number: D3245041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20615M33

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 54.0000 Each(s)
Rivet

M18235x54

106277

AS 07/12/19

(6)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

mf 08-01-15-
mf 08-01-09-
mf 07-12-19-

(4)
(2)
(5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.01.23

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part# and batch# using fine point ink marker and Stock
Location: ST 183

AS 08/01/24

(x5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.25

(4)

Job Completion




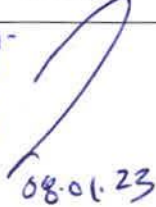


2008/1/24

N

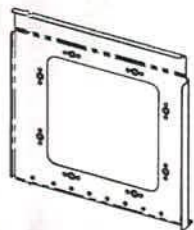
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-041 PAR #: 012 Fault Category: Prod - Sur - Mod - Frg NCR: Yes No DQA: 1A Date: 08.01.25
QA: N/C Closed: 1A Date: 08.01.28

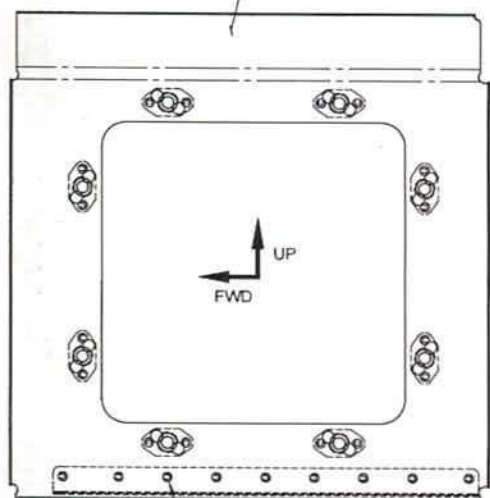
NCR: 35649		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.09	6.0	D3245-1 Pannel was found to have Dents Around the installation on the MS20427M3-3 Rivets. RC the counter sinks were not correctly done. Hammering rivets		Drill out affected Rivets with A SOFT FACE HAMMER Flatten out Dents. Scrap & destroy Part. re-work is unacceptable.	mf 08.01.23 mf 08.01.23 mf.			

NOTE: Date & initial all entries



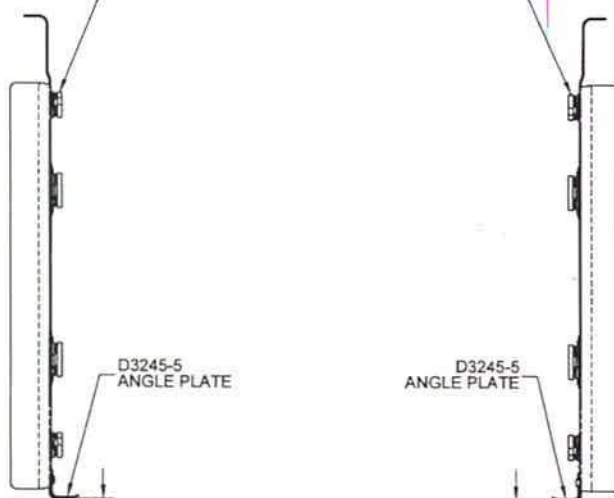
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

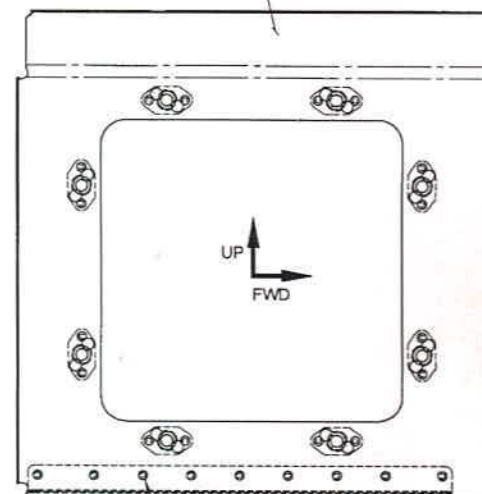


D3245-5
ANGLE PLATE

0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

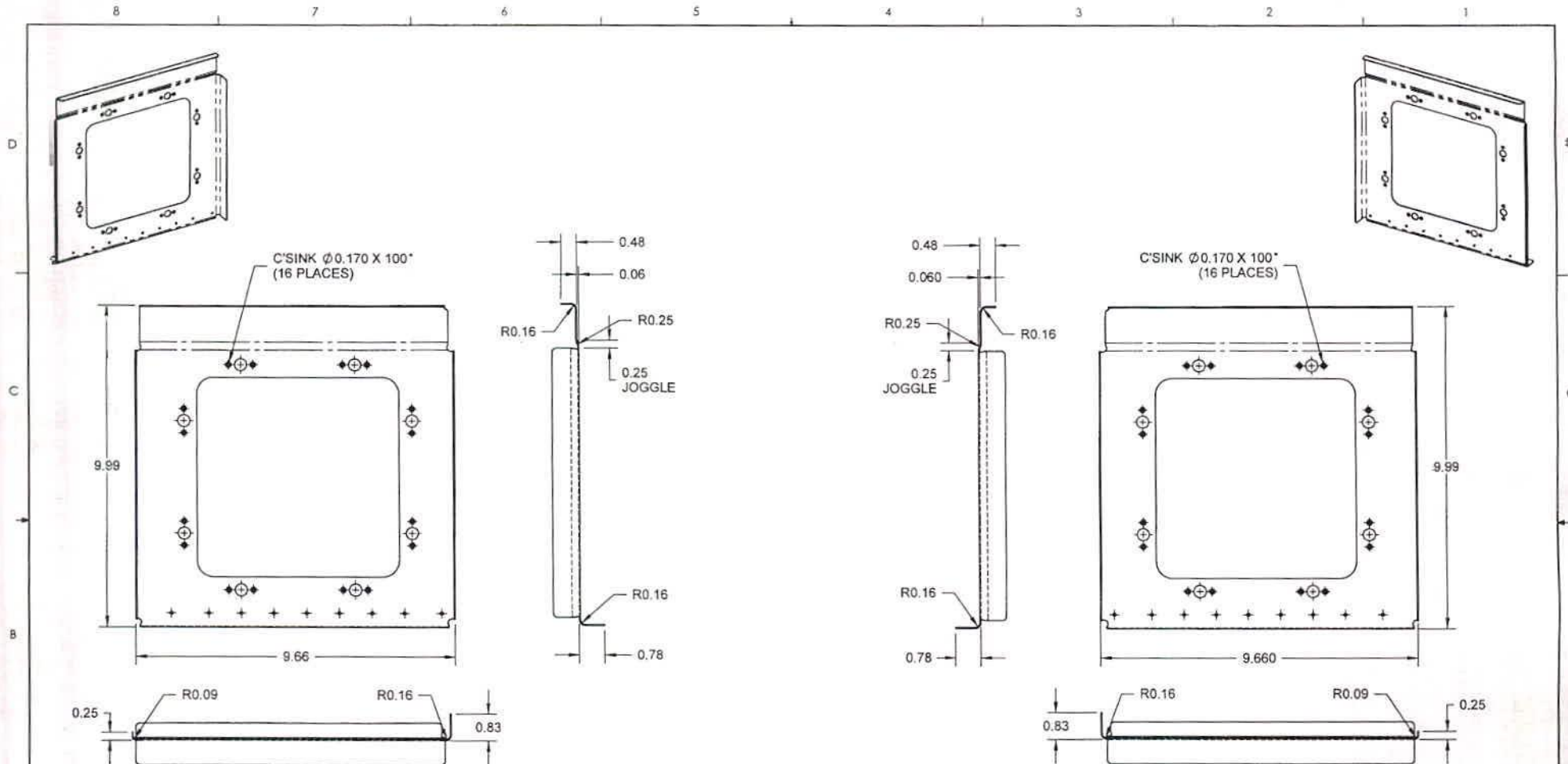
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/-2. REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3245	SHEET 1 OF 7
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	12.5
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DATE	07.10.02		

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WORK ORDER
55649



D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED
10-23

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	140	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY 1:3	
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D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET
(REF)

8.00
(TYP, REF)

D3245-043 DOOR ASSEMBLY

INSTALL D3245-7
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

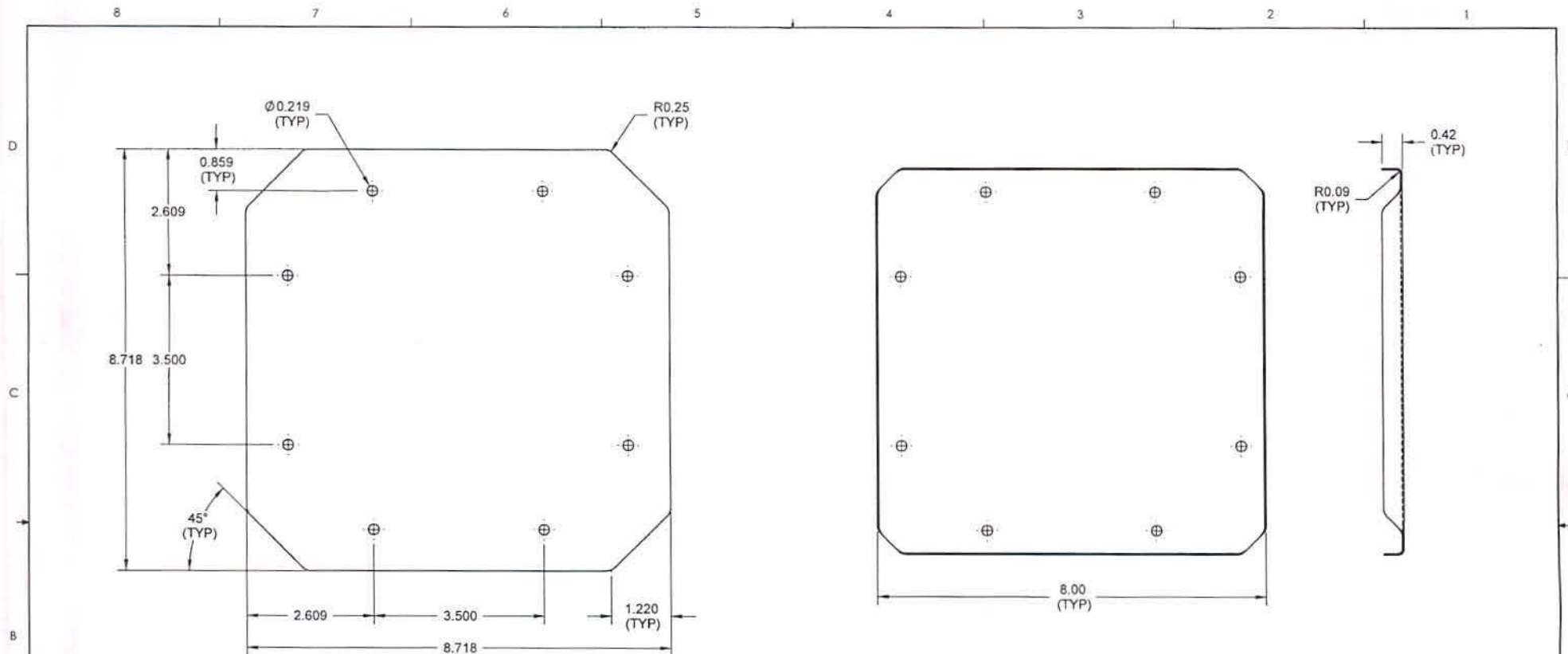
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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APPROVED		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
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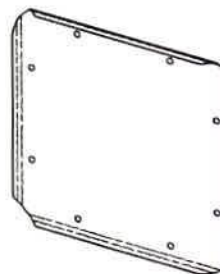
D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR BENDING DETAIL

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07-10-02

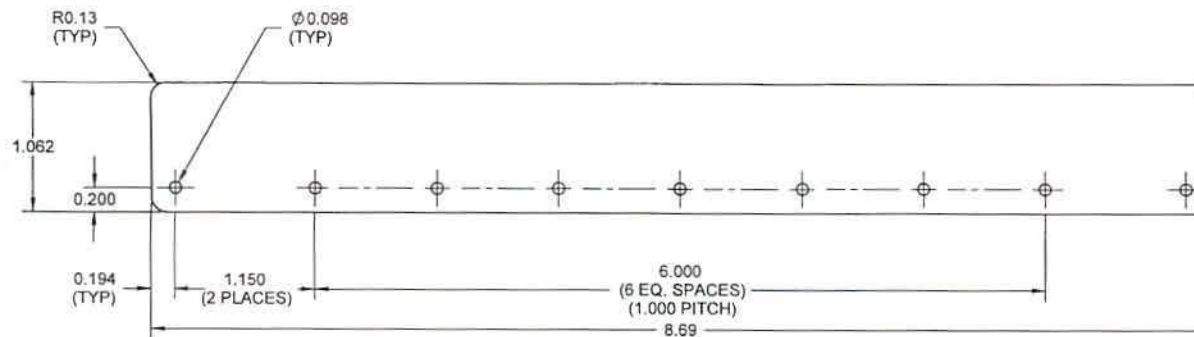
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

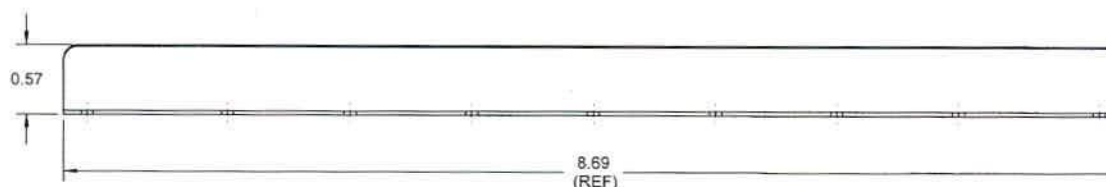


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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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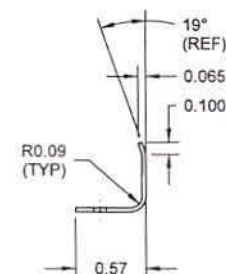
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D3245-5F FLAT PATTERN



D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)



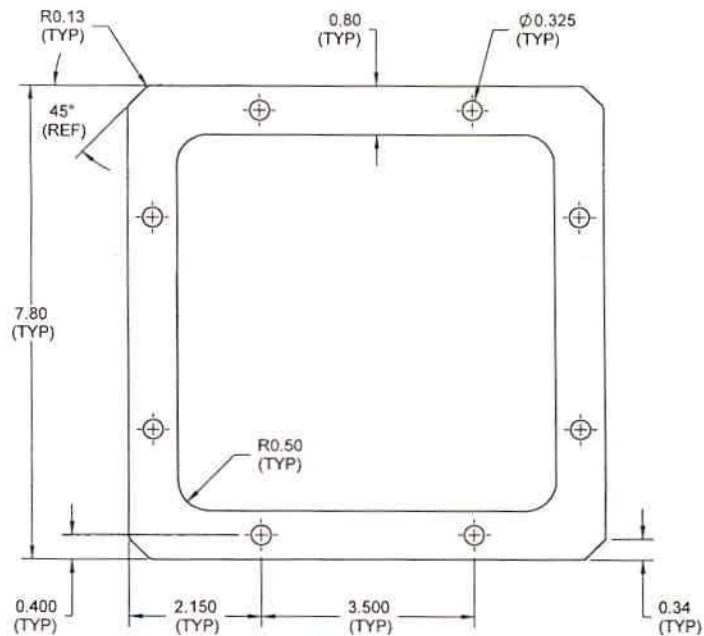
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07.10.23

NOTES:

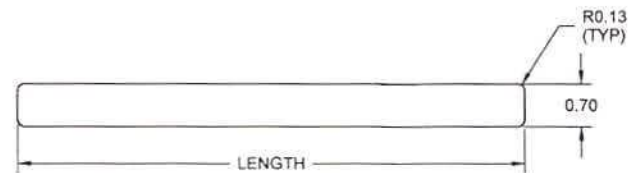
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		TITLE	SHEET 5 OF 7
APPROVED		ACCESS PANEL ASSEMBLY	SCALE 1:1
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D3245-7 GASKET






D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED
07.10.03

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3245	SHEET 7 OF 7
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DE APPR.		ACCESS PANEL ASSEMBLY	1:2
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SHEET 6 OF 7